

Date: Thursday, 3/13/2008 10:19:54 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG	
Job Number	: 37926		Part Number	: D25941	
Estimate Number	: 10178		Drawing Number	: D2594 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 3/13/2008	S.O. No. :	Drawing Revision	: C	
Prsht Rev.	:	NC	Material	:	
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 4/15/2008	Qty: 500 Um: Each
Previous Run	:	37419			
Written By	:	<u>J.F. 08/03/13</u>			
Checked & Approved By	:				
Comment	: Est D 02.08.22 Make in Cobra KJ	est E 06.12.11 ecn 836 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
	Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	Batch <u>M106634</u> J.F. 08/03/23
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.	J.F. 08/03/17
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/03/17
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	J.F. 08/03/24
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005.4.1	J.F. 08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING <i>m 107005</i> <i>BR 08-03-27</i> <i>518</i>
Comment: POWDER COATING Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>m-f</i> <i>08/03/28</i> <i>518A</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>F-P 1</i> <i>m-f 08/03/28</i> <i>518X</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
9.0	QC21	FINAL INSPECTION/W/O RELEASE <i>m-f</i> <i>08/04/03</i> <i>mf</i> <i>08-03-28.</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		<i>w</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37926
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08-03-17	Date:	08/03/17	Date:	

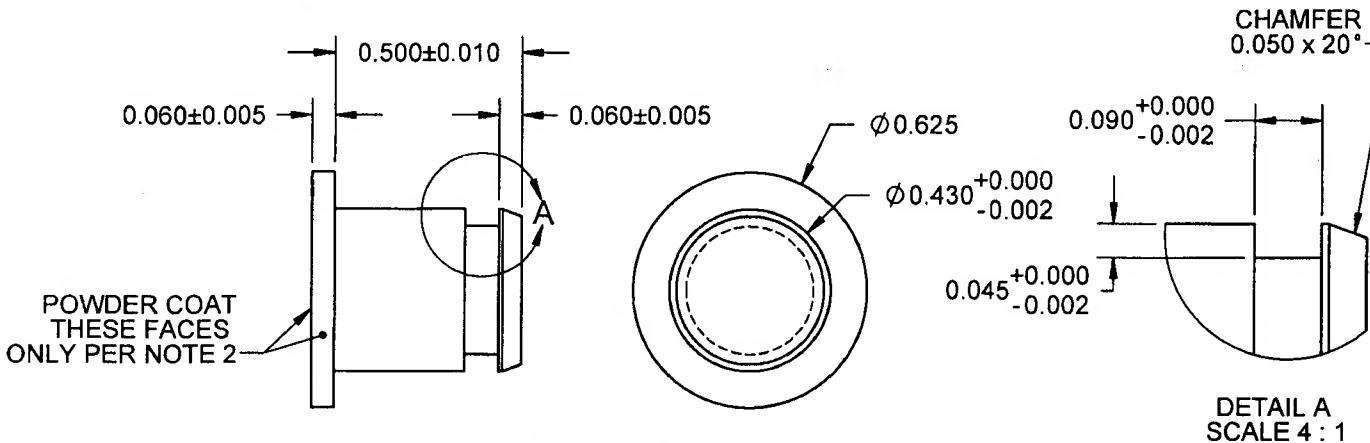
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594
DATE 06.11.20		TITLE PLUG

REV. C
SHEET 1 OF 1
SCALE
2:1DART AEROSPACE LTD
06.11.28 *[Signature]*

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

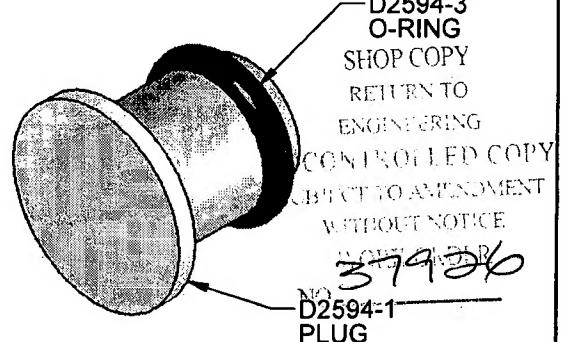
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

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